

Work Order ID 70857

Thursday, June 16, 2011 2:21:49 PM



Page 1

Item ID: D3463-7

Revision ID:

Item Name: Drag Arm

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/23/2011 Req'd Qty: 12.00

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan: *MF*Date: *6/16/11*

QC: _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3463	Rev B

100 0.00



Small Fab

Small Fab

Memo

0.00

1-Cut to 13.875"

2-Deburr

3-Bend end as per dwg D3463

SB 116764
EB (12)

110 0.00



QC

Quality Control

Memo

0.00

DU 11/07/04
(12)

120 0.00



Mill Conv

Conventional Milling Machine

Memo

0.00

1-Mill as per dwg D3463

2-Drill hole & ream to 0.4385" as per dwg D3463

3-Deburr

10 11/07/05
12
** Check off your length **

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Item Name: Drag Arm

Stop



Start Date: 6/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
Description

130

QC2- Inspect parts off machine FAI/FAIB



QC

Quality Control

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

B.A 11/07/06

12

0

150



Small Fab

Small Fab

0.00

Memo

0.00

Grind .450" rad

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Work Order ID 70857

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Page 3

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Item Name: Drag Arm

Stop



Start Date: 6/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Sides 100

42

170



Packaging

Packaging

Identify as per dwg & Stock Location: *W/A*

0.00

E 11-7-6

XP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/16/11

MC
11-04-06

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 2:21:55 PM

Page 1

Work Order ID: 70857



Parent Item: D3463-7



Parent Item Name: Drag Arm

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV> A 05.11.18 new issue EC
IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.750W.120



Purchased

No

100

f

29.4400

1.15625

14.60526



304 ss round tube .750 x .120w

Location

MAT017

Loc Qty

29.44

Loc Code

114706

29.44

ES 11/16/2011
14.60526

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

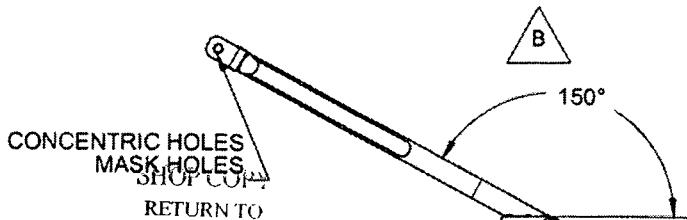
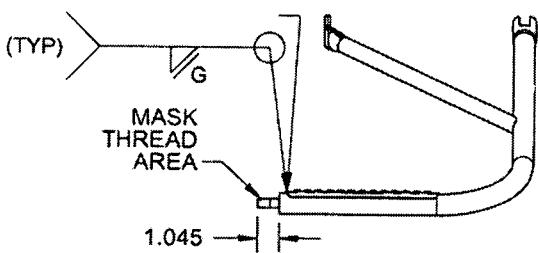
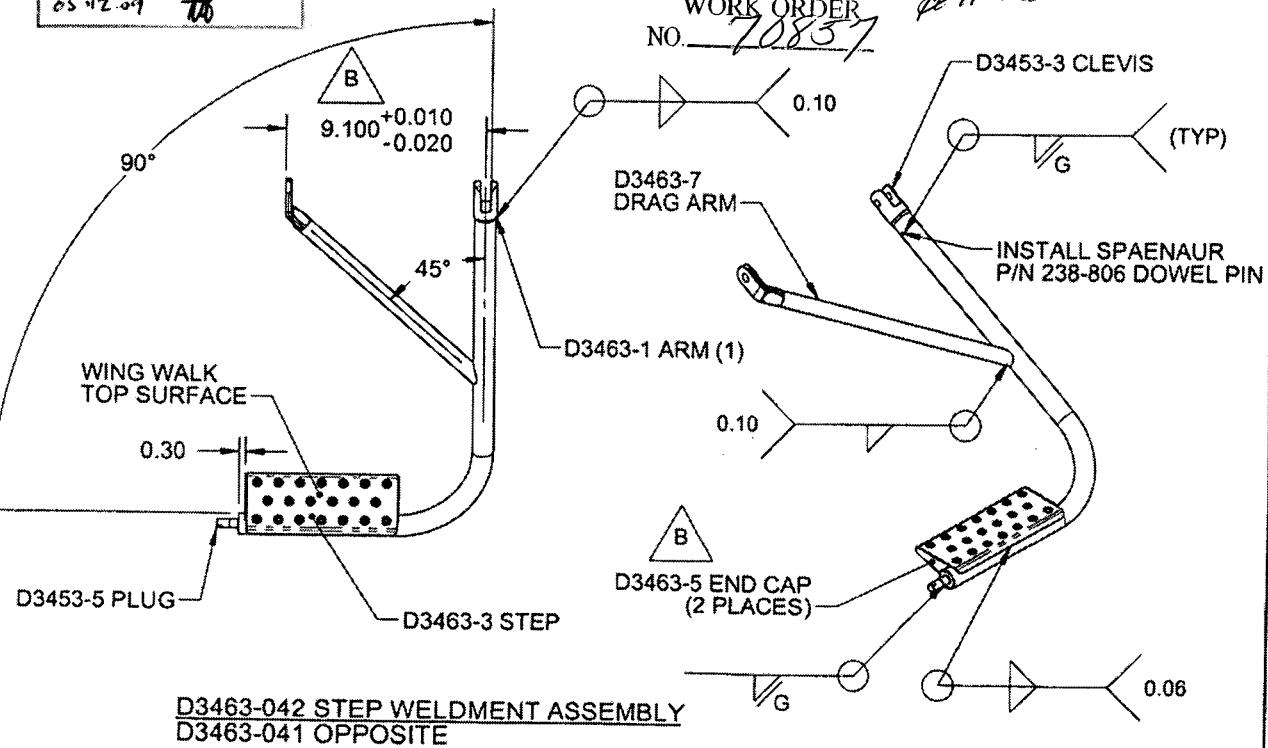
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NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

INSTALL P/N 238-806
DOWEL PIN**RELEASED**05.12.05 *[initials]*UNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDER
NO. *70837**05.12.05***NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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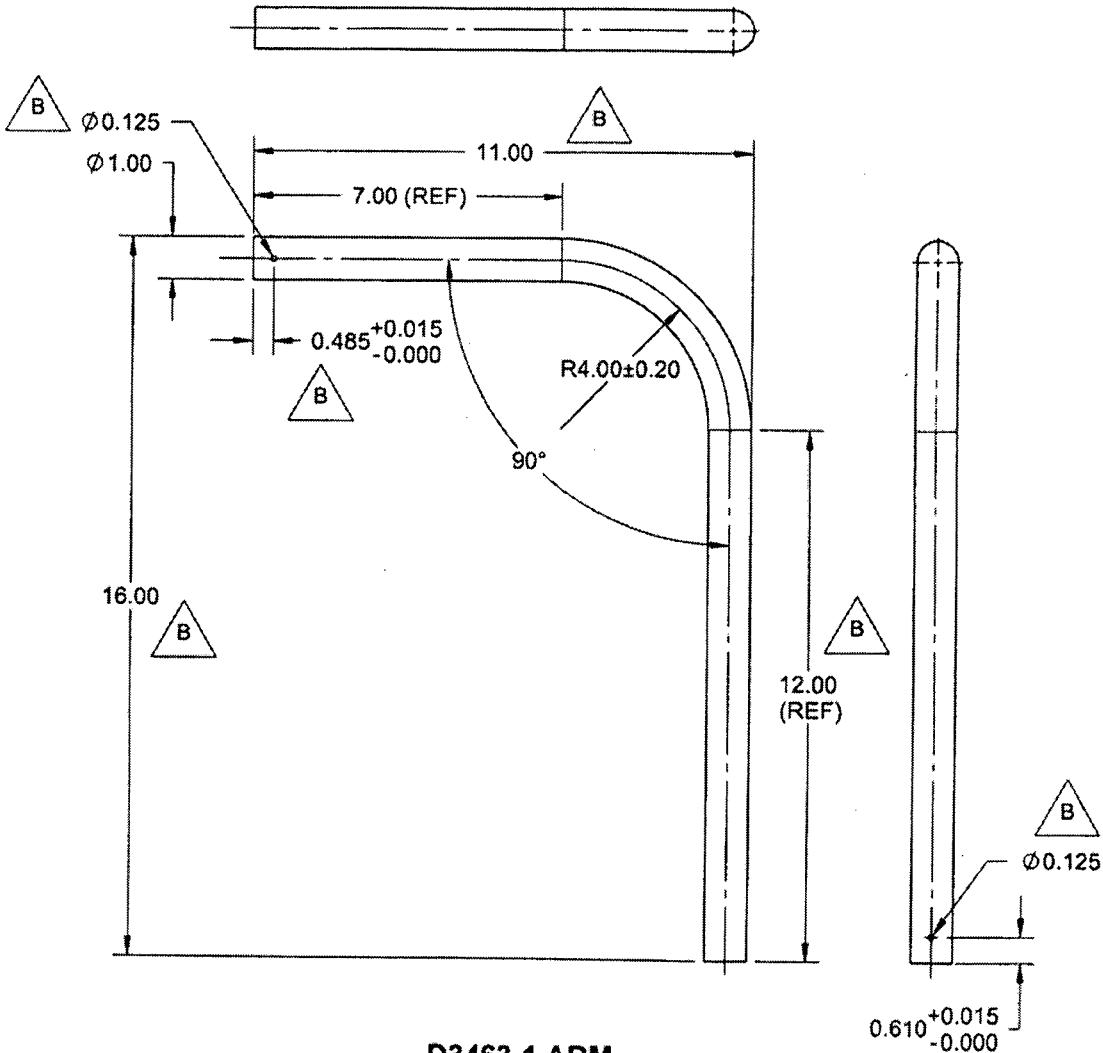
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463
DATE 05.12.05		REV. B SHEET 2 OF 4 TITLE STEP WELDMENT SCALE 1:4

RELEASED

05.12.09 *[Signature]**W0 70857*D3463-1 ARM**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

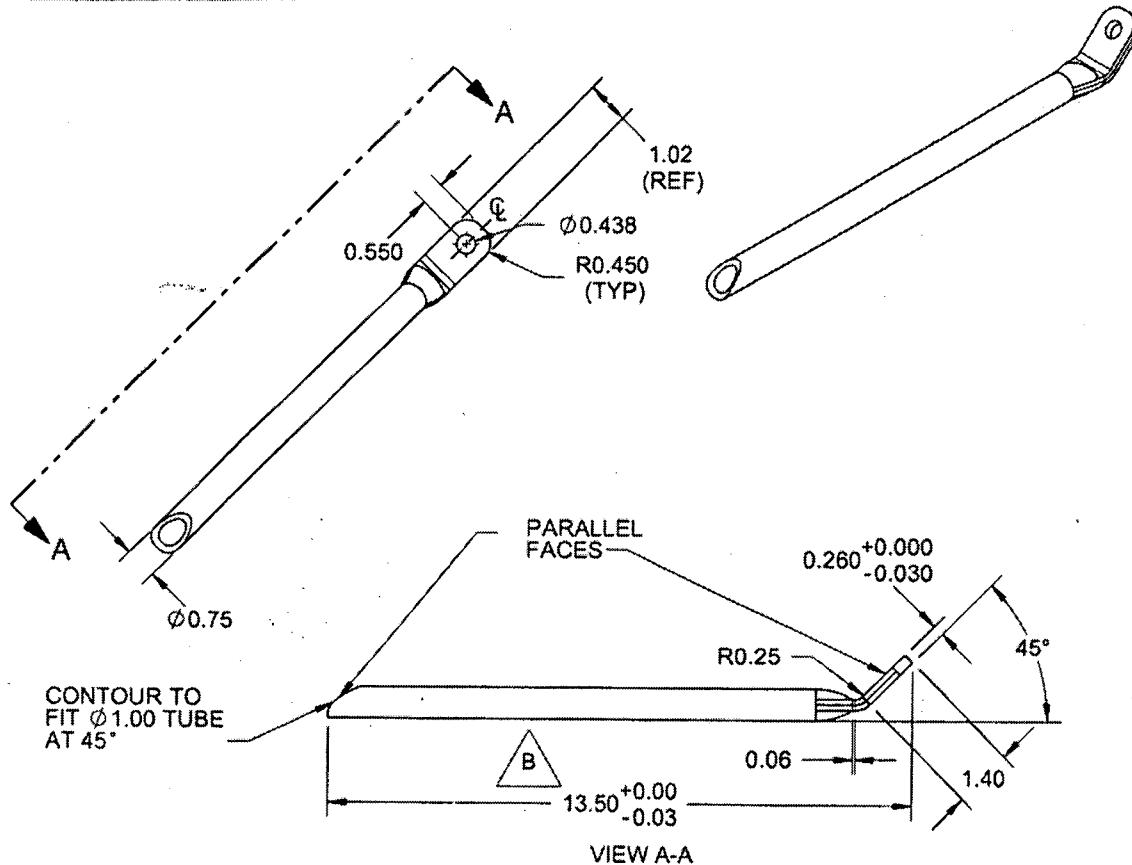
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463
DATE 05.12.05	TITLE STEP WELDMENT	REV. B SHEET 3 OF 4 SCALE 1:4

RELEASED

05.12.05 *[initials]**WB 70857***D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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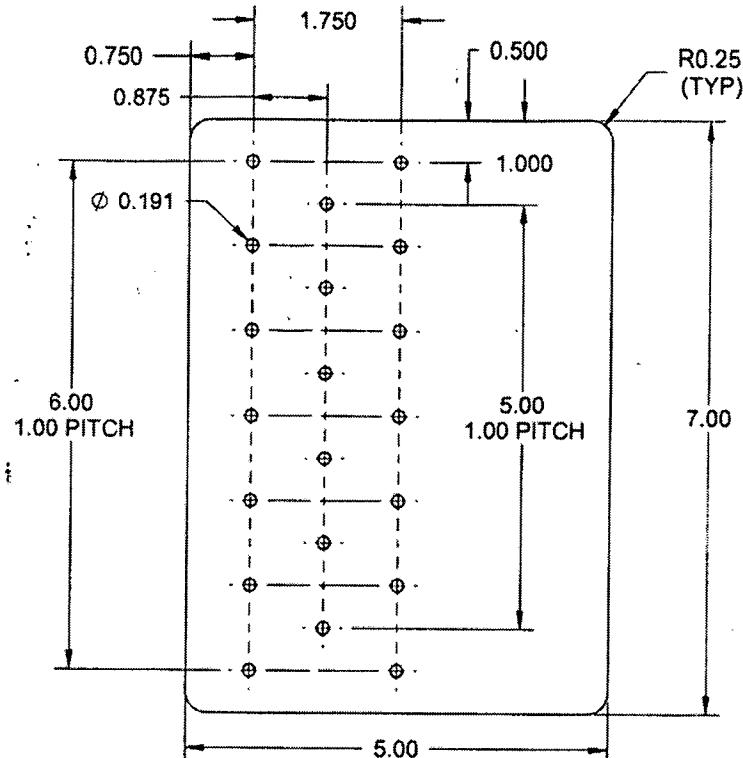
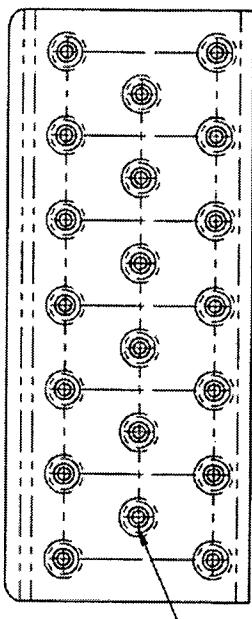
NOTE: Date & initial all entries



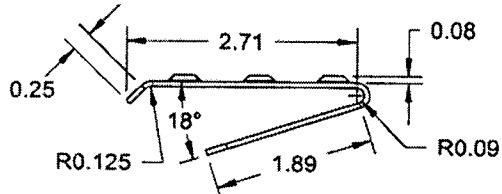
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:2	

RELEASED

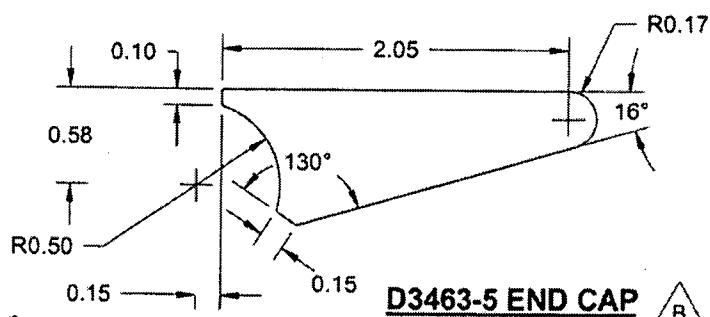
05.12.05 *[initials]*



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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WORK ORDER CHANGES

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DART AEROSPACE LTD	Work Order:	70857
Description: Drag Arm	Part Number:	3463-7
Inspection Dwg: 3463 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

1

First Article

X

Prototype

Measured by: *[Signature]*
Date: 11/07/05

Audited by:	J.A
Date:	11/07/06

Prototype Approval: _____
Date: _____

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	

